

Date: Tuesday, 7/10/2007 1:05:45 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 33451		
Estimate Number	: 10346		
P.O. Number	: N/A	Part Number	: D2596
This Issue	: 7/10/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2596 REV D
First Issue	: N/A	Project Number	: N/A
Previous Run	: 33348	Drawing Revision	: D
	Type : LANDING GEAR	Material	: N/A
Written By	: <u><i>[Signature]</i></u>	Due Date	: 7/17/2007
Checked & Approved By	: <u><i>[Signature]</i></u>	Qty:	4 Um: Each
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Ext'n -I' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	B31223

Batch

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid Etch and Alodine per QSI 005 4.1

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP

7-7-20

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: R2 Date: 07/18/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:05:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 33451

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 4/6

DP 2-2-20

(4)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DP 10-7-23 (4)

Job Completion



DP 07-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

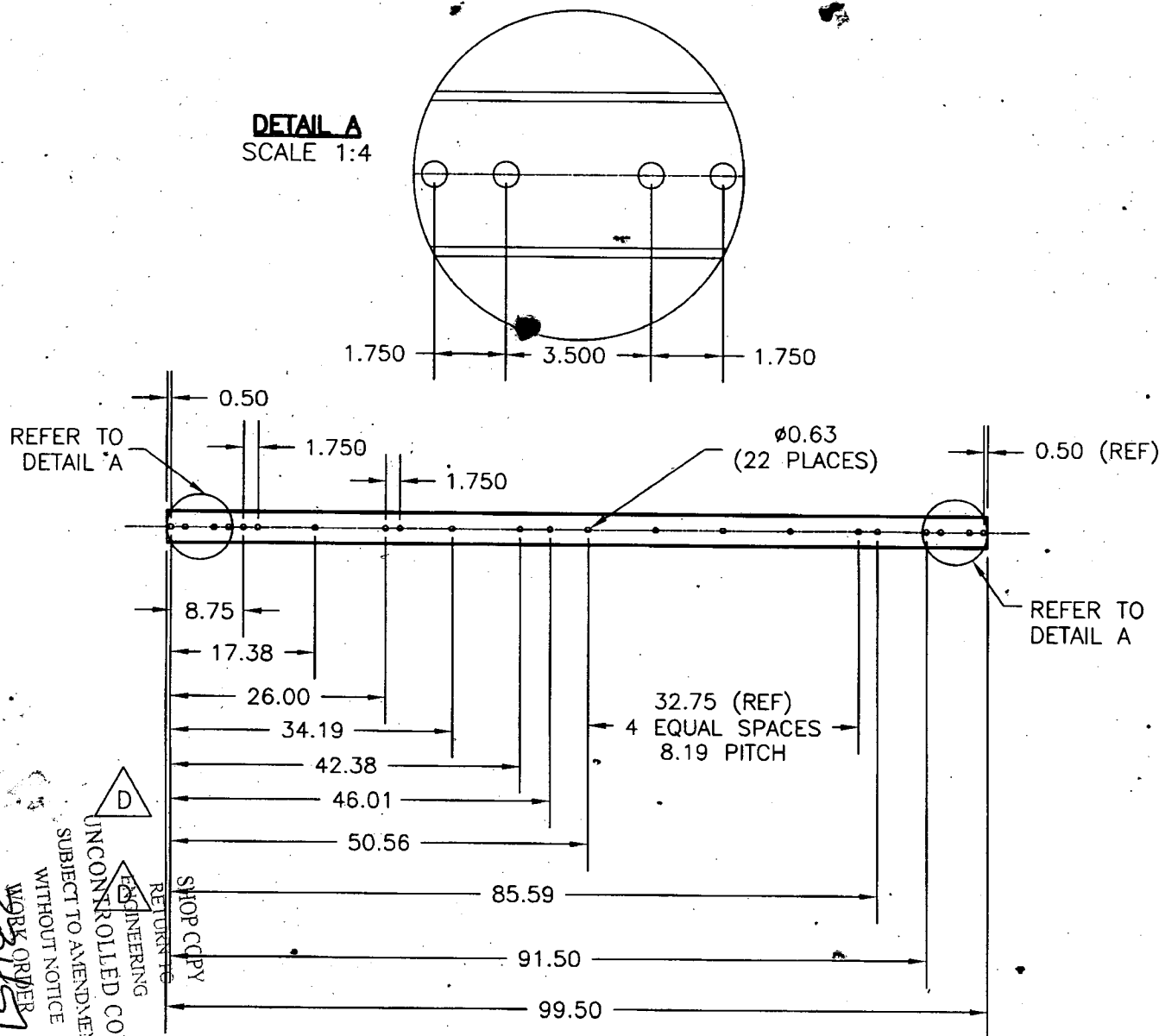
NOTE: Date & initial all entries

DART

RELEASED
07.06.18

DESIGN	PA	DRAWN BY	AT	DART AEROSPACE LTD	REV. D
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	TH	APPROVED	TH	DRAWING NO.	SHEET 1 OF 1
				D2596	
DATE	07.04.17	TITLE			SCALE
				205 WEB	1:20
A		96.09.16	NEW ISSUE		
B		97.07.23	Ø0.63 HOLE WAS Ø0.56		
C		98.09.14	INCORPORATED DEO 9097		
D		07.04.17	INCORPORATED DEO 9183		

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

D

UNCONTROLLED COPY

ENGINEERING

RETURN TO

SHOP COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 33451

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